

Date: Monday, 23/02/2009 2:59:54 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER
Job Number : 46005
Estimate Number : 10287
P.O. Number :
This Issue : 23/02/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 42224
Written By :
Checked & Approved By : JUD 09.02.23
Comment :
Est Rev:B No Longuer Made In House 05-11-06 JLM
Est Rev:C Now on Waterjet 07-04-18 JLM
Est Rev:D chg to revC as per dwg 08-04-21 DD
verified by:JLM
Part Number : D32021
Drawing Number : D3202 REVC
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 05/03/2009 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M5052H32S032

5052-H32 .032 Sheet



Comment: Qty.: 1.6286 sf(s)/Unit Total : 19.5426 sf(s)

5052-H32 .032 Sheet

Batch: 109488 *

ml 09 02 24

(12)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: CProg Rev: C

2-Deburr if necessary

ml 09 02 24

(12)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 02 24



(12)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/02/24

(12)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 09 02 24

(12)

09/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 2:59:54 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 46005

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11109648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 9:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30am

09-02-06

12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



12

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-26

8.0

PACKAGING 1

PACKAGING RESOURCE #1



12

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 241A

9/2/06

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

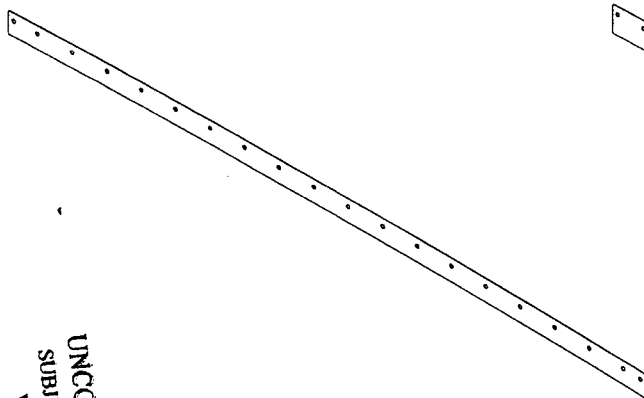
A

D

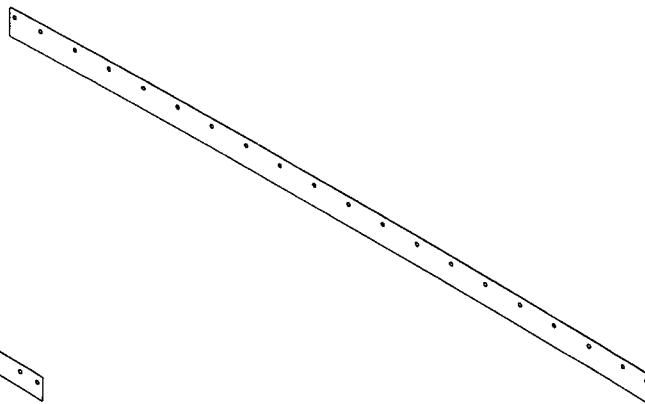
C

B

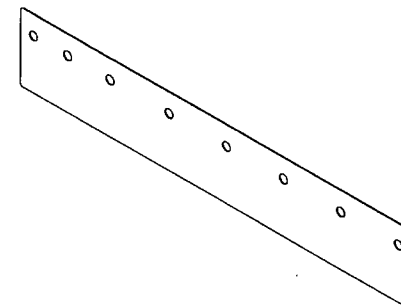
A



D3202-1 COVER



D3202-3 COVER
(COMPOSITE DOOR)



D3202-5 COVER
(HINGE PANEL DOOR MOD)



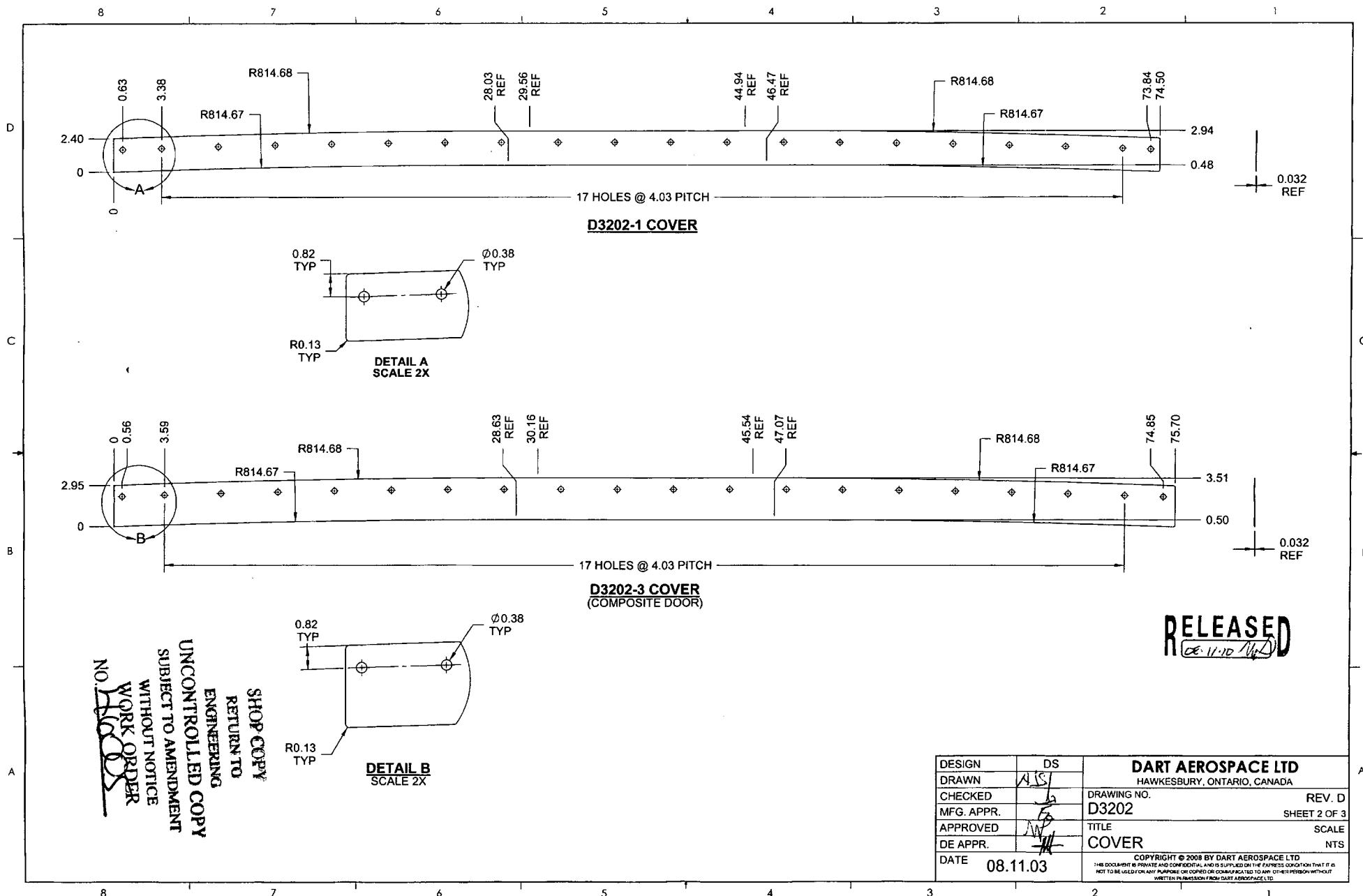
RELEASED
08.11.03

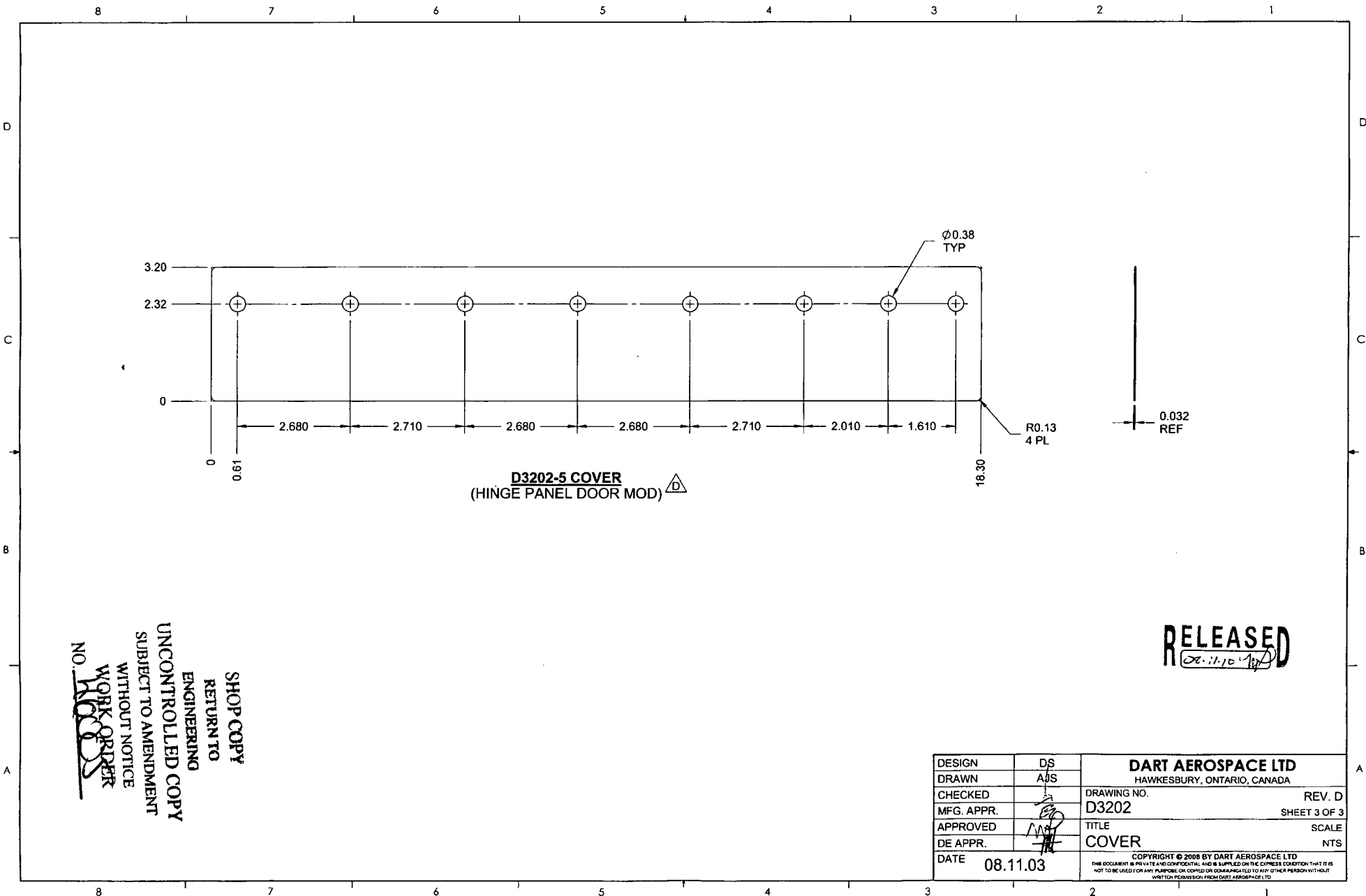
NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3
: 0.18 lbs APPROX FOR -5

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 41005

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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D3202-5 COVER
(HINGE PANEL DOOR MOD) \triangle

RELEASED
08.11.03

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DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3202	REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
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